



In another prior-art procedure, the hole structures are created by (cold) stamping/cutting the fibers out of the bonded fleece. Such procedures have the advantage that hard stamped or melted edges do not arise, and materials obtained in this manner are soft. A disadvantage is that this procedure can only be done when the fleece is conveyed at a slow speed. In addition, the fibers are shortened along the holes which decreases the strength of the fleece.

A disadvantage of the cited procedures is that material is unnecessarily destroyed or wasted by hot and cold stamping or burning.

In another prior-art procedure in EP 0 214 608 A2, the fleece is manufactured and the hole structures are created by two rollers between which the fleece is guided. One roller has numerous heated needles, and the other roller has corresponding holes to receive the needles of the first roller. The needles purportedly displace the fibers while forming the hole structures and simultaneously form recesses around the hole structures, and they seal the edges of the hold structures by melting the fibers. In this procedure, the fibers are not shortened or destroyed, however hard melted edges arise that negatively influence the softness. In addition, it is involved and expensive to introduce hole structures after the fleece is thermobonded.

The problem of the invention is therefore to create a procedure that enables professionals to manufacture a fleece with hole structures that feels soft, the bond of the fibers is not weakened by introducing hole structures, the procedure can be done without waste, and it is simple and economical.

This problem is solved with a procedure of the initially-cited type that has the features of patent claim 1.